

Work Order ID 126185

126185

Page 1

Thursday, October 30, 2014 10:07:17 AM

Item ID: D5022-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Foam, Side Panel, Aft **4**
Start Date: 10/30/2014 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/30/2014 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: MCS Date: 10-10-30 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D5022 | B | | | | | | | | |

110 0.00

110

Purchasing

Memo

0.00

Purchasing

Issue P/O: 26351

Manufacture as per Dwg

Possible supplier: ACP COMPOSITES TPI

C OF C note is required.

CK 10/11/03 & 4

120

Receive & Inspect for Damage & Mat'l Certs

0.00

120

Packaging

Memo

0.00

Packaging

C OF C note is required.

4X SP 14-11-10

130

QC6- Inspect dimensions to drawing

0.00

130

QC

Memo

0.00

Quality Control

4 DAB 27 9:00 14/11/12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 126185

Thursday, October 30, 2014 10:07:17 AM

126185

Page 2

Item ID: D5022-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Foam, Side Panel, Aft

Start Date: 10/30/2014 Start Qty: 6.00

6

Cust Item ID:

Required Date: 10/30/2014 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

Identify as per dwg & Stock Location: mt

0.00

140

Packaging

Memo

0.00

Packaging

(4)

DMS
27
9-00

4/11/12

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

4/11/12

4-11-12

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

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|--|--|---|--|

Picklist Print

Thursday, October 30, 2014 10:07:22 AM

Page 1

Work Order ID: 126185

126185

Parent Item: D5022-3

D5022-3

Parent Item Name: Foam, Side Panel, Aft

Start Date: 10/30/2014

Required Date: 10/30/2014

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 13.12.20 NEW ISSUE DD VERF:JLM IPP REV.
B 14/01/09 QTY CHANGE FOR D5033-1 DL IPP REV:C
14.04.09 NOW OUTSOURCE DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|----------|--|-----------|--|----|--|--|------|--------|--|--|--|--|--|
| D5022-3P | | Purchased | | No | | | Each | 0.0000 | | | | | |
|----------|--|-----------|--|----|--|--|------|--------|--|--|--|--|--|

D5022-3P

Foam, Side Panel, Aft

**

LP-FC 125-FC 1-9

m130210

5.5SF = 27.5SF

C21411103

4X 8814/11-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

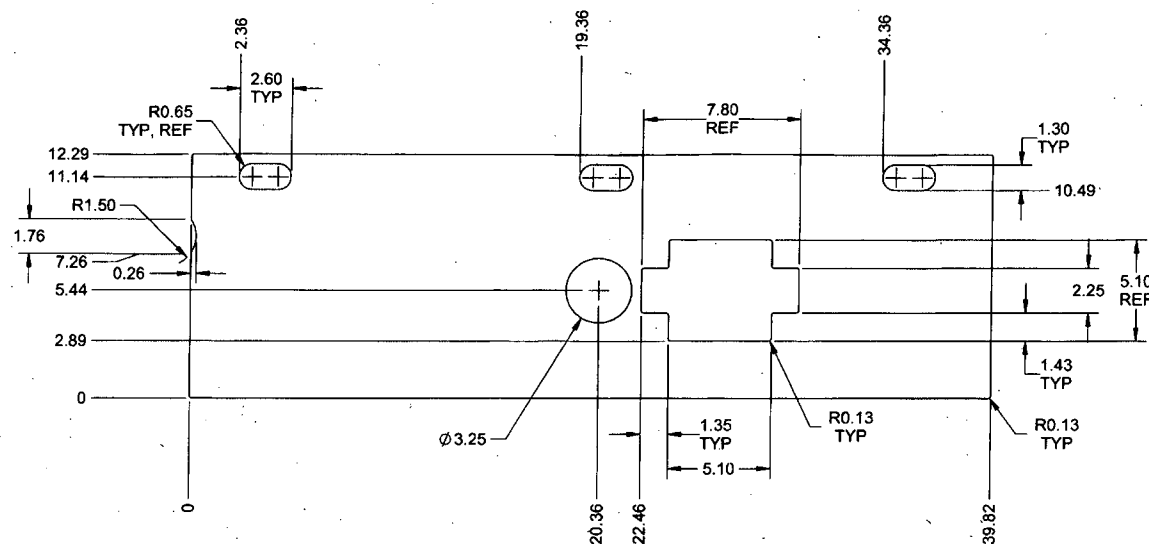
Work Order update only ☐

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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
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| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
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| | | <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO 126185 MLS

14-10-30

RELEASED
2014-01-22

D5022-3 FOAM, SIDE PANEL, AFT, LH

NOTES:

- 1) MATERIAL: D5033-1 (RIGID POLYURETHANE FOAM)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.19 lbs

| | | | |
|------------|--------------------|--|------------------------|
| DESIGN | RF | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | RF | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D5022 | REV. B SHEET 2 OF 3 |
| MFG. APPR. | <i>[Signature]</i> | TITLE FOAM CORE | SCALE NTS |
| DE APPR. | <i>[Signature]</i> | DATE 14.01.09 | |

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WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
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| Training | | | | | | | | | |
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|--|--|---|--|

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO26351

Purchase Order Date 11/3/2014

PO Print Date 11/5/2014

Page Number 2 of 3

Order From :

VC-TPI001

Ship To : DART AEROSPACE LTD

TPI INDUSTRIES INC.
148 RUE GOODFELLOW
DELSON, QUEBEC J5B 1V4
CANADA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

450-633-0484

Ship To Contact

Ship To Phone

Ship Via:

TST Overland

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Total: \$39.00

| | | | | | | |
|---|--------|----------------------------|------------|-------|---------|----------|
| 4 | 126184 | D5022-1 FOAM SIDE PANEL | 11/10/2014 | 12.00 | \$12.69 | \$152.28 |
|---|--------|----------------------------|------------|-------|---------|----------|

Yes

11/10/2014

CUT AS PER DWG D5022-1 REV. B

Line Total: \$152.28

| | | | | | | |
|---|--------|----------------------------|------------|------|--------|---------|
| 5 | 126185 | D5022-3 FOAM SIDE PANEL | 11/10/2014 | 4.00 | \$8.38 | \$33.52 |
|---|--------|----------------------------|------------|------|--------|---------|

Yes

11/10/2014

CUT AS PER DWG D5022-3 REV. B

Line Total: \$33.52

| | | | | | | |
|---|--------|----------------------------|------------|------|--------|---------|
| 6 | 126186 | D5022-5 FOAM SIDE PANEL | 11/10/2014 | 4.00 | \$9.02 | \$36.08 |
|---|--------|----------------------------|------------|------|--------|---------|

Yes

11/10/2014

CUT AS PER DWG D5022-5 REV. B

Note:

11/5/2014

T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6399
Date: 2014-11-06
Page: 1

| | |
|---|--|
| Sold to: | Ship to: |
| Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada | Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada |
| Order No.: 100812 | Sold By: JONATHAN LESSARD |
| Shipped By: | Ship Date: 2014-11-06 |
| Tracking No.: | |

| Item No. | Unit | Description | Quantity |
|---|--------|--------------------------------|----------|
| d2995 | Chaque | d2995.bearpaw | 6 |
| d4353-041 | Chaque | d4353-041 bearpaw | 6 |
| d5022-1p | Chaque | d5022-1p foam, side panel, fwd | 12 |
| d5022-3p | Chaque | d5022-3p foam, side panel, aft | 4 |
| d5022-5p | Chaque | d5022-5p foam, side panel, aft | 4 |
| d4353-3 | Chaque | d4353-3 bearpaw | 6 |
| | | PO 26351 | |
| SP14-11-10 | | | |
| Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours | | | |